Dart Aerospace Ltd. Monday, 8/21/2006 2:14:12 PM Date: Kim Johnston User: **Process Sheet** : SPACER : CU-DAR001 Dart Helicopters Services **Drawing Name** Customer : 28274 Job Number **Estimate Number** : 11167 : NIA Part Number : D32783 P.O. Number S.O. No. : N/A : D3278 REV B : 8/21/2006 **Drawing Number** This Issue : N/A Project Number : NC Prsht Rev. : MA Type : MACHINED PARTS **Drawing Revision** First Issue : NIA : 27869 Material **Previous Run** : 8/28/2006 Qty: 50 Um: **Due Date** Written By Checked & Approved By New issue KJ/JLM Comment : Est A04.04.19 **Additional Product** Job Number: Description: Seq. #: **Machine Or Operation:** 1.0 MDELRINS0125X300 Black Delrin Comment: Qty.: 0.0361 sf(s)/Unit Total: 1.8060 sf(s) Black Delrin Use DT8685 Router Table. Material: Black Delrin/UHMW 0.125" thick (M-DELRIN-S0.125x30.0) Identify for D3278-3 Batch: M101657 SAB FLOW WATER JET 2.0 Comment: FLOW WATER JET 1-Cut as per Dwg D3278 Dwg Rev: _____ Prog Rev: B

SAI)

06:08:24

(58)

Each

2-Deburr if necessary

ISPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5AD

25:08:2**4**

4.0

3.0

QC8

SECOND CHECK

-ds-08.28 =

Comment: SECOND CHECK

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector				
							<u></u>				

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action Section B	· · · · · · ·	Verification	Approval	Approval
DATE	STEP	Section A	Initial Design Mgr	Action Description Design Mgr	Sign & Date	Section C	Design Mgr	QC Inspector
ob of 2d	2	2 Harts were not in tolerance (hole's)	den	Scrap and destray - replace	5A-8 06:03:24	06-08-28	woon	00 00 24
				·				

Part No:	PAR #:	Fault Category:	NCR:	Yes No DQA:	Date: 06/09/06
NOTE: Date & initial all entries				QA: N/C Closed:	Date:

Monday, 8/21/2006 2:14:13 PM Date: Kim Johnston User: **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: SPACER Job Number: 28274 Part Number: D32783 Job Number: Description: Seq. #: **Machine Or Operation:** SMALL & MEDIUM FAB RESOURCE 1 SMALL FAB 1 5.0 Comment: SMALL & MEDIUM FAB RESOURCE 1 1-C'sink as per dwg D3278 2-Deburr PACKAGING RESOURCE #1 6.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 7.0 DC Comment: DOCUMENT CONTROL 20409/06 Inspection Level 21 CL06109105 Job Completion 4

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W/O:	0		WO	RK ORDER CHA	ANGES					
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NCR:	· ·	•	WORK ORDE				'		F	1
DATE	STEP	Description of NC Section A	Corrective Action Section B Initial Action Description			Sign &	Verification Section C		Approval Design Mgr	Approval QC Inspecto
			Design Mgr	Design Mgr		Date				
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Part No	o:	PAR #:	Fault Category	:	NCR: Ye	s No	DQA:		Date:	
NOTE: [ate & initial	all entries			0/	A: N/C C	losad:		Date:	

DART AEROSPACE LTD	Work Order:	28274
Description: Spacer	Part Number:	D3278-3
Inspection Dwg: D3278 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

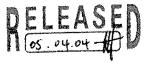
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.98	+/-0.030	1.996	\		Vern	
1.98	+/-0.030	1,999	/		Vern	
1.480	+/-0.005	1,483	/		Vern	
0.250	+/-0.010	0.25			Vern	
1.480 、	+/-0.005	1.484			Vern	
0.250	+/-0.010	0,255	~		Vern	
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100°	+/-0.1°	NIA				Sanstep. 5
R0.12	+/-0.030	RO.12	/		R-b	
0.125	+/-0.010	0.125	~		Vern	

Measured by: 540	Audited by:	Prototype Approval:	N/A
Date: 06:08:24	Date:	Date:	N/A

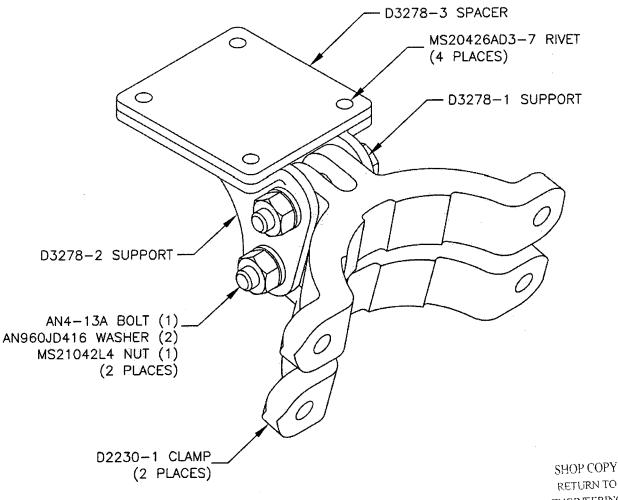
	Rev	Date	Change		Revised by	Approved	
ĺ	A	04.04.19	New Issue	P/O D3278-041	KJ/JLM 1/A		
	В	06.03.09	Dwg Rev updated		KJ/JLM 🤫		
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DATE		·	TITLE	SCALE
05.0	3.31		SUPPORT ASSEMBLY	NTS
Α		04.03.03	NEW ISSUE	The second state of the second
В		05.03.31	CHANGE DIM/TOL TO ENSURE FIT	



D3278-041 SUPPORT ASSEMBLY



RETURN TO ENGINEERING JNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE

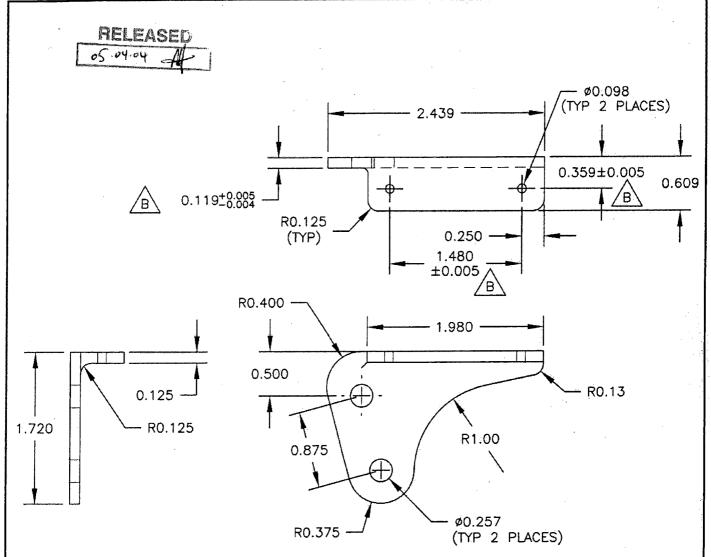
WORK ORDER / NO 282

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DESIGN	DRAWN BY		OSPACE LTD ONTARIO, CANADA
CHECKED	APPROVED A	DRAWING NO.	REV. B
#	#	D3278	SHEET 2 OF 3
DATE	<u> </u>	TITLE	SCALE
05.03.31		SUPPORT ASSEMBLY	1:1



D3278-1 SUPPORT (SHOWN) D3278-2 SUPPORT (OPPOSITE)

1) MACHINE PER DWG FILE "D3278-1.SLDPRT"

SHOP COPY 2) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/8 OR QQ-A-250/6 OR ENGINEERING (REF DART SPEC. M6061T6B OR M6061T6S)

3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3 UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE

4) BREAK ALL SHARP EDGES 0.005 TO 0.015

5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

6) ALL DIMENSIONS ARE IN INCHES

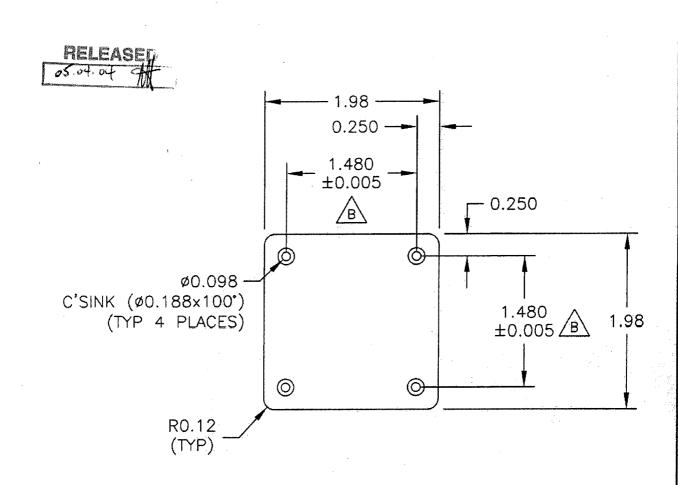
WORK ORDER

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CHECKED	APPROVED #	DRAWING NO. D3278			SHEET	REV. 3 OF	-
DATE		TITLE				SCA	LE.
05.03.31		SUPPORT /	ASSEMB	LY	(4)		1:1



SHOP COPY

D3278-3 SPACER

RETURN TO

- 1) MATERIAL: BLACK DELRIN / UHMW PER DART SPEC M-DELRIN-B OR M=DELRIN-S UNCONTROLLED COPY 0.125 THICK
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES.

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